

shg 16/07

Work Order ID 60519



Page 1

Tuesday, July 13, 2010 11:09:33 AM

Item ID: D3955-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Doubler Assembly

Start Date: 7/13/2010 Start Qty: 4.00



Cust Item ID:

Required Date: 7/20/2010 Req'd Qty: 4.00



Customer:

Reference:

Run Start



Approvals: Process Plan: K

Date: 10-7-13

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3955	A								
100		0.00							
Waterjet	Memo	0.00							
FLOW CNC Waterjet	1-Cut as per Dwg D3955-1								
	Dwg Rev: <u>A</u>								
	Prog Rev: <u>A</u>								
	2-Deburr if necessary								
110	QC2- Inspect parts off machine FAI/FAIB	0.00							
QC	Memo	0.00							
Quality Control									

ml 10 07 14 (4)

ml 10 07 24 (4)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 60519

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Page 2

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Start Date: 7/13/2010 Start Qty: 4.00

Required Date: 7/20/2010 Req'd Qty: 4.00

Reference:

Cust Item ID:

Customer:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120



QC

Quality Control

QC8- Inspect parts - second check

0.00

Memo

0.00

8/10/07/14

(74)

130



Small Fab

Small Fab

Memo

1- C'sink holes as per dwg

2- Deburr if necessary

0.00

0.00

= 7 m. 10/07/14

(48)

140



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

8/10/07/14

(29)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Work Order ID 60519

Tuesday, July 13, 2010 11:09:33 AM

Page 3

Item ID: D3955-041

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Revision ID:

Item Name: Doubler Assembly

Start Date: 7/13/2010 Start Qty: 4.00

Required Date: 7/20/2010 Req'd Qty: 4.00

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start
Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

150

Chemical Conversion Coat per QSI005 4.1

0.00

0.00

= 7m, 10/07/14 (4X)

HandFinish

Memo

Hand Finishing

160

QC3- Inspect Part Finish

0.00

0.00

SB 10/07/14

(4)

QC

Memo

Quality Control

170

Pick Kit

0.00

0.00

= 7m, 10/07/14 (4X)

Packaging

Memo

Packaging

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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NOTE: Date & initial all entries

Work Order ID 60519

Tuesday, July 13, 2010 11:09:33 AM

Page 4

Item ID: D3955-041

Accept

Revision ID:

Item Name: Doubler Assembly

Start Date: 7/13/2010 Start Qty: 4.00

Required Date: 7/20/2010 Req'd Qty: 4.00




Reference:

Cust Item ID:

Customer:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start
Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180  Small Fab Small Fab	Memo 1- Assemble nut plate as per dwg	0.00 0.00				(4X)			
190  QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00				(44)			
200  Packaging Packaging	Identify as per dwg & Stock Location: <u>102</u> Memo	0.00 0.00							

= 7m - 10/07/14

8 10/07/14

10/14/14 (4)

Dart Aerospace Ltd

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QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

210

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

ME 10-7-14

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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NOTE: Date & initial all entries

Picklist Print

Tuesday, July 13, 2010 11:09:37 AM

Page 1

Work Order ID: 60519

Parent Item: D3955-041

Parent Item Name: Doubler Assembly

Start Date: 7/13/2010

Required Date: 7/20/2010

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP RevA: New issue DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

M6061T6S.063

Purchased

No

100

sf

118.7600

0.3553

1.496



6061-T6 .063 Sheet

Location

Loc Qty

Loc Code

MAT21

118.76

113608

118.76

MS21086L3

Purchased

No

180

Each

18.0000

1

4



Nut Plate

Location

Loc Qty

Loc Code

ST304

18

112219 ✓

18

MS20427M3-3

Purchased

No

180

Each

532.0000

2

8



Rivet

Location

Loc Qty

Loc Code

ST318

532

112933 ✓

8

113064 ✓

524

ml 10.07.14

4x ml 10/07/14

8x ml 10/07/14

W/O:		WORK ORDER CHANGES						
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NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	60519
Description: Doubler		Part Number:	D3955-1
Inspection Dwg: D3955	Rev: A	Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article
 ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.129	+0.005/-0.001	0.131	✓		vern	
Ø0.201	+0.005/-0.001	0.202	✓		vern	
0.750	+/-0.010	0.748	✓		H.G	
1.000	+/-0.010	1.003	✓		H.G	
1.250	+/-0.010	1.255	✓		H.G	
1.375	+/-0.010	1.374	✓		H.G	
2.38	+/-0.030	2.38	✓		H.G	
0.613	+/-0.010	0.613	✓		H.G	
1.313	+/-0.010	1.313	✓		H.G	
2.063	+/-0.010	2.063	✓		H.G	
2.563	+/-0.010	2.563	✓		H.G	
3.063	+/-0.010	3.067	✓		H.G	
4.813	+/-0.010	4.818	✓		H.G	
6.313	+/-0.010	6.310	✓		H.G	
7.313	+/-0.010	7.312	✓		H.G	
7.813	+/-0.010	7.813	✓		H.G	
8.199	+/-0.010	8.200	✓		H.G	
8.449	+/-0.010	8.449	✓		H.G	
9.188	+/-0.010	9.190	✓		H.G	
9.438	+/-0.010	9.435	✓		H.G	
10.413	+/-0.010	10.413	✓		M.T	
10.75	+/-0.030	10.75	✓		M.T	
0.063	+/-0.010	0.060	✓		vern	

Measured by:	MR. M	Audited by:	S	Prototype Approval:	N/A
Date:	10.07.14	Date:	10.07.14	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	09.07.29	New Issue	KJ	

W/O:			WORK ORDER CHANGES					
DATE	STEP		PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

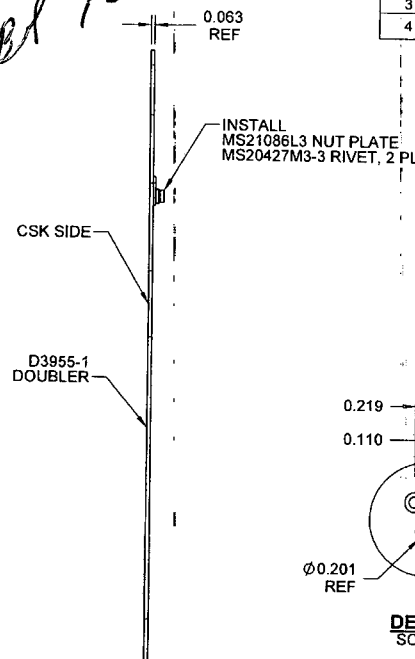
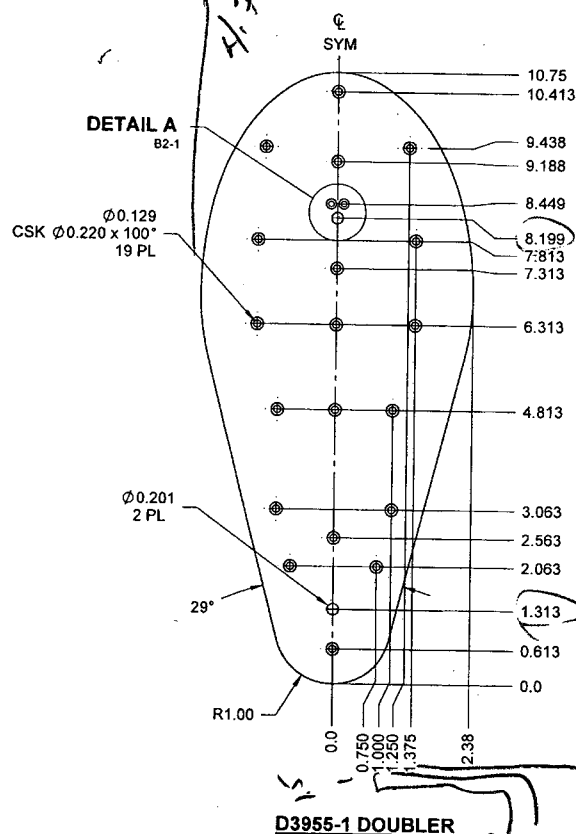
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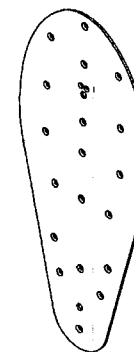
NOTE: Date & initial all entries

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 60519
BL 10-7-13

ITEM	QTY	P/N	DESCRIPTION
1	X	D3955-041	DOUBLER ASSY
2	1	D3955-1	DOUBLER
3	1	MS21086L3	NUT PLATE
4	2	MS20427M3-3	RIVET



DETAIL A D7-1
SCALE 2X



D3955-041 DOUBLER ASSEMBLY

RELEASED
09/07/22

D3955-1 NOTES:

- 1) MATERIAL: 6061-T6 ALUMINUM, 0.063 THICK SHEET PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027 (REF. DART SPEC. M6061T6S.063)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART ASSEMBLY P/N "D3955-041" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.25 lbs

A NEW ISSUE		RF	09.07.21
REV.	DESCRIPTION	BY	DATE
DESIGN	DS		
DRAWN	RF		
CHECKED		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
MFG. APPR.		DRAWING NO.	REV. A
APPROVED		D3955	SHEET 1 OF 5
DE APPR.		TITLE	SCALE
DATE	09.07.21	SKIDTUBE TUNING KIT	NTS

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Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

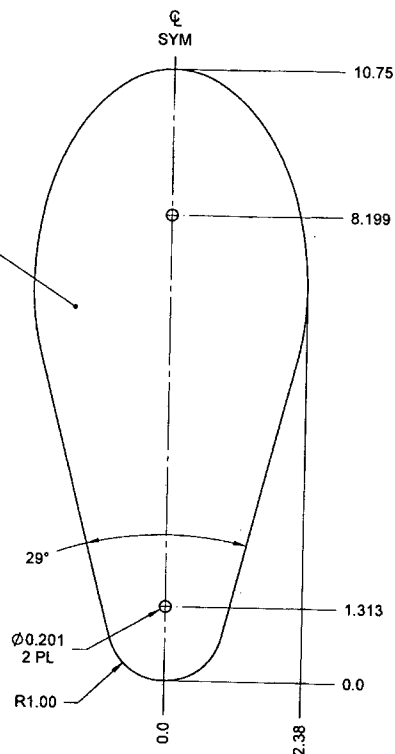
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

APPLY ANTI-SKID
ON ONE SIDE ONLY



D3955-3 COVER PLATE

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET, 0.060 (16 GA) THICK (REF. DART SPEC. M304S16GA)
- 2) FINISH: BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3955-3" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.64 lbs

0.060 REF

RELEASED
09/07/21

DESIGN	DS	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3955	SHEET 2 OF 5
APPROVED		TITLE	SCALE
DE APPR.		SKIDTUBE TUNING KIT	NTS
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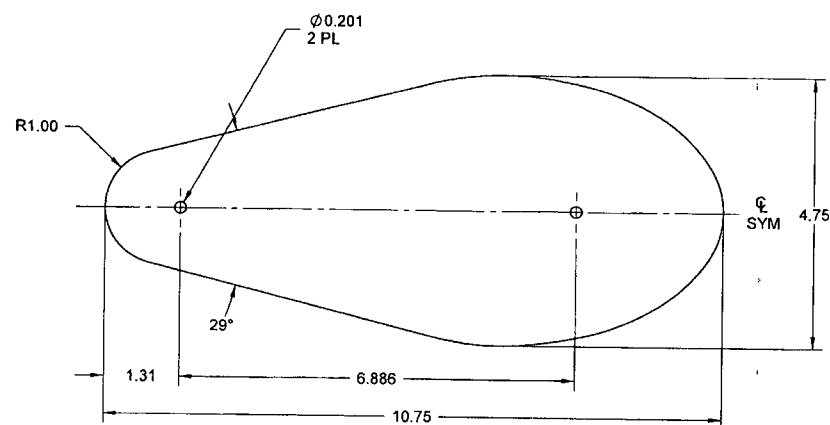
W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries



D3955-X PLATE

General Table			
P/N	T (in)	T (GA)	WEIGHT (lbs)
D3955-6	0.060	16	0.64
D3955-7	0.120	11	1.28

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET, T (GA) THICK (REF. DART SPEC. M304ST'GA)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3955-X" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: SEE TABLE

WLB 60519

RELEASED
01/07/21 MDD

DESIGN	DS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
DRAWN	RF	
CHECKED		DRAWING NO. D3955 REV. A
MFG. APPR.		SHEET 3 OF 5
APPROVED		TITLE SKIDTUBE TUNING KIT SCALE NTS
DE APPR.		
DATE	09.07.21	

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Dart Aerospace Ltd

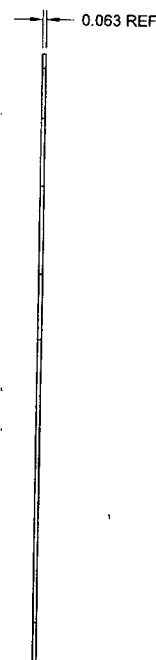
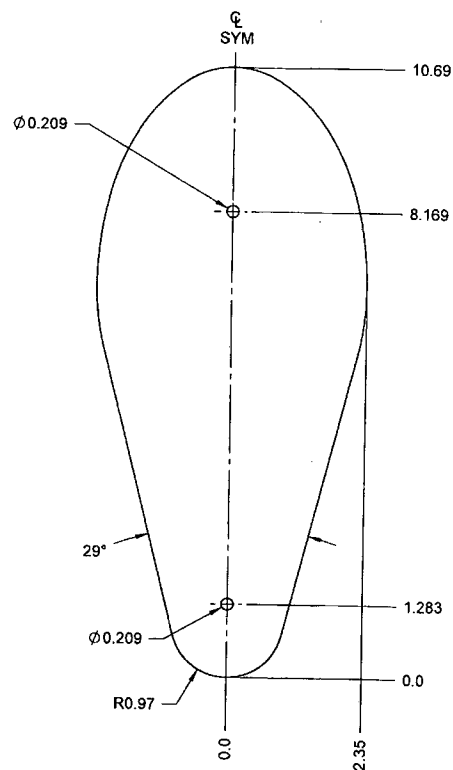
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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WLB 60519

D3955-21 GASKET

D3955-21 NOTES:

- 1) MATERIAL: BLACK NEOPRENE SHEET, 0.063 THICK, 60 DUROMETER (REF. DART SPEC. M-NEO60-S.063)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3955-21" USING YELLOW PAINT MARKER
- 7) WEIGHT: 0.08 lbs

RELEASED
21/07/22 NW

DESIGN	DS	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3955	SHEET 4 OF 5
APPROVED		TITLE	SCALE
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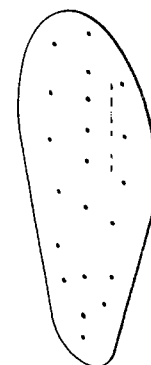
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
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W/O 60519

RELEASED
9/67/2M

DESIGN	DS		DART AEROSPACE LTD	
DRAWN	RF		HAWKESBURY, ONTARIO, CANADA	
CHECKED			DRAWING NO.	REV. A
MFG. APPR.			D3955	SHEET 5 OF 5
APPROVED			TITLE	SCALE
DE APPR.			SKIDTUBE TUNING KIT	NIS
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